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D5610-1TRN
Job Sheet 191953



Part No: D5610-1TRN

Job Qty: 1 ea

Part Name: EC130 Aft Crosstube Turning Detail



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/13/19

Job Tracking No:

Due Date: 4/12/19

Created By: Linda Lacelle

Type: Stock

Description:

Note: D5610 REV.B IPP REV.A 18.07.04 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		4/12/19	0.00	0.00	Start Up Crosstubes-1		2019-03-26
100	Mori Seiki	1 pcs		4/12/19	4.40	2.38	Mori Seiki TL-40		
110	QC	1 pcs		4/12/19	0.00	0.00	QC2-1		
120	Mori Seiki	1 pcs		4/12/19	0.00	2.38	Mori Seiki TL-40		2019-03-28
130	QC	1 pcs		4/12/19	0.00	0.00	QC2-1		
140	QC	1 pcs		4/12/19	0.00	0.00	QC8		37-19-01
145	Crosstubes	1 pcs		4/12/19	0.00	0.68	Crosstubes-1		J-89
150	HandFXtube	1 pcs		4/12/19	0.00	1.00	Crosstubes-3		
160	QC	1 pcs		4/12/19	0.00	0.00	QC7-1		
170	Packaging	1 pcs		4/12/19	0.00	0.00	Packaging3-1		
180	QC21-SA	1 Ea		4/12/19	0.00	0.00	QC21		

Part Op 100 - 1- Fill tube with sand & install plugs 2- Face and chamfer both ends as per Folio FC197 3- Turn first taper section on
Descriptions: both side

120 - 1- Turn second taper on both side 2- Scribe part # and batch # using vibrating stylus on the cuff as per Dwg D5610-TRN

145 - GRIND ONLY TRANSITION LINES SMOOTH LONGITUDE WAY.

150 - 1- handfinish X-TUBE INSIDE AND OUT

170 - LOCATION : LG014

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6030-140	Tube, Seamless	1 pcs (1 ea)	90-Start up Operation	5078768

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6030-140	1	5	0

Part Specifications

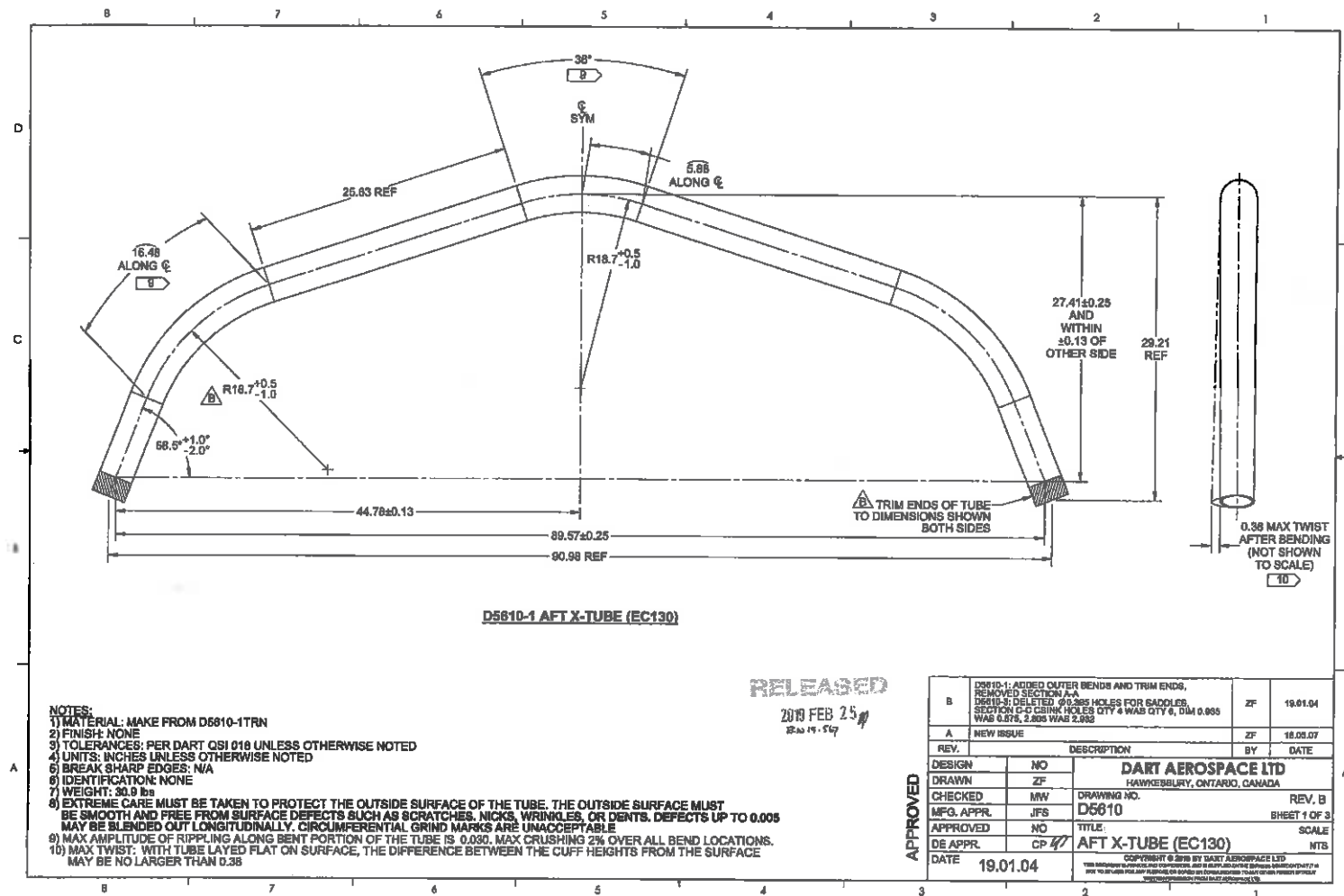
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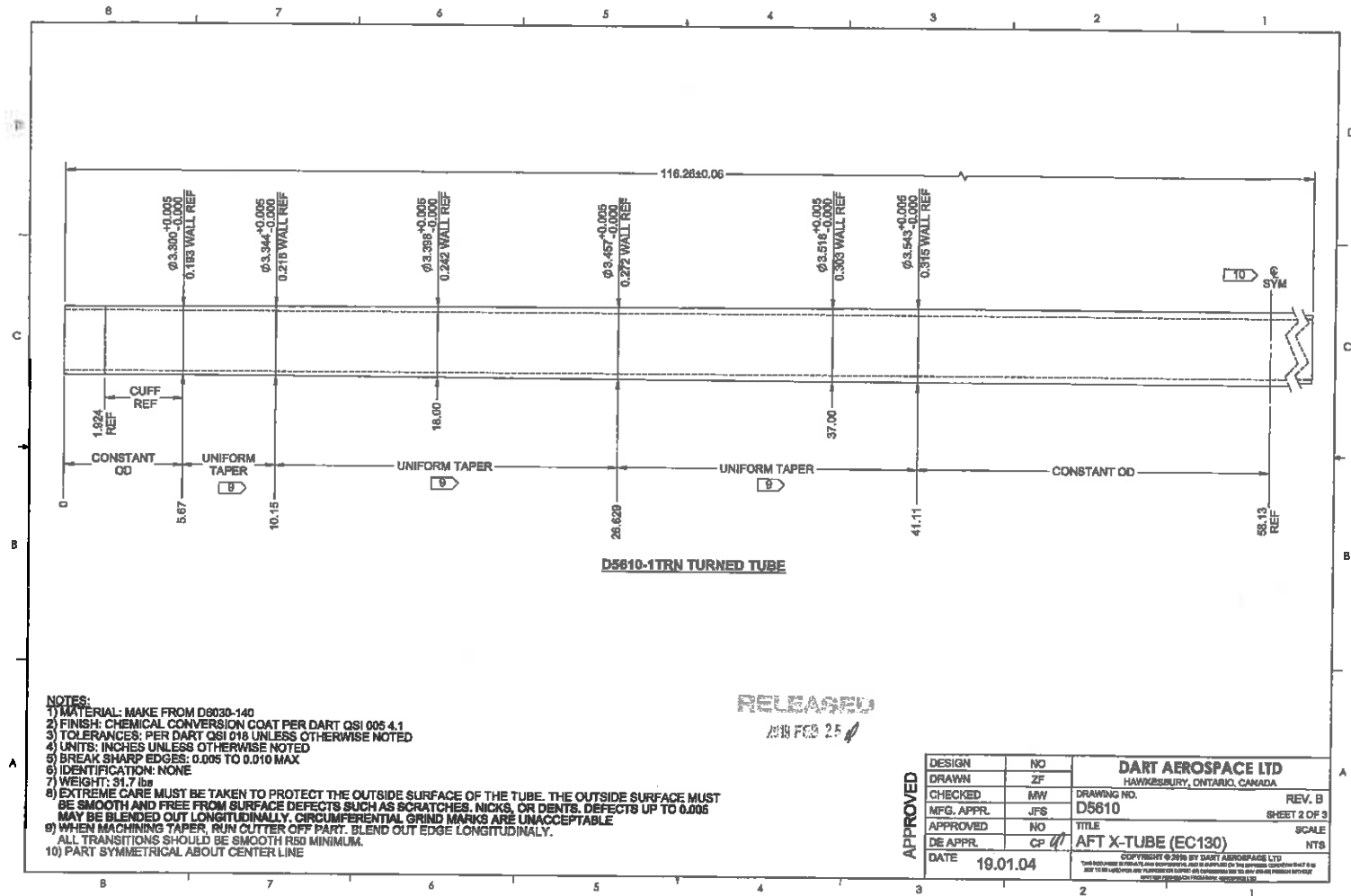
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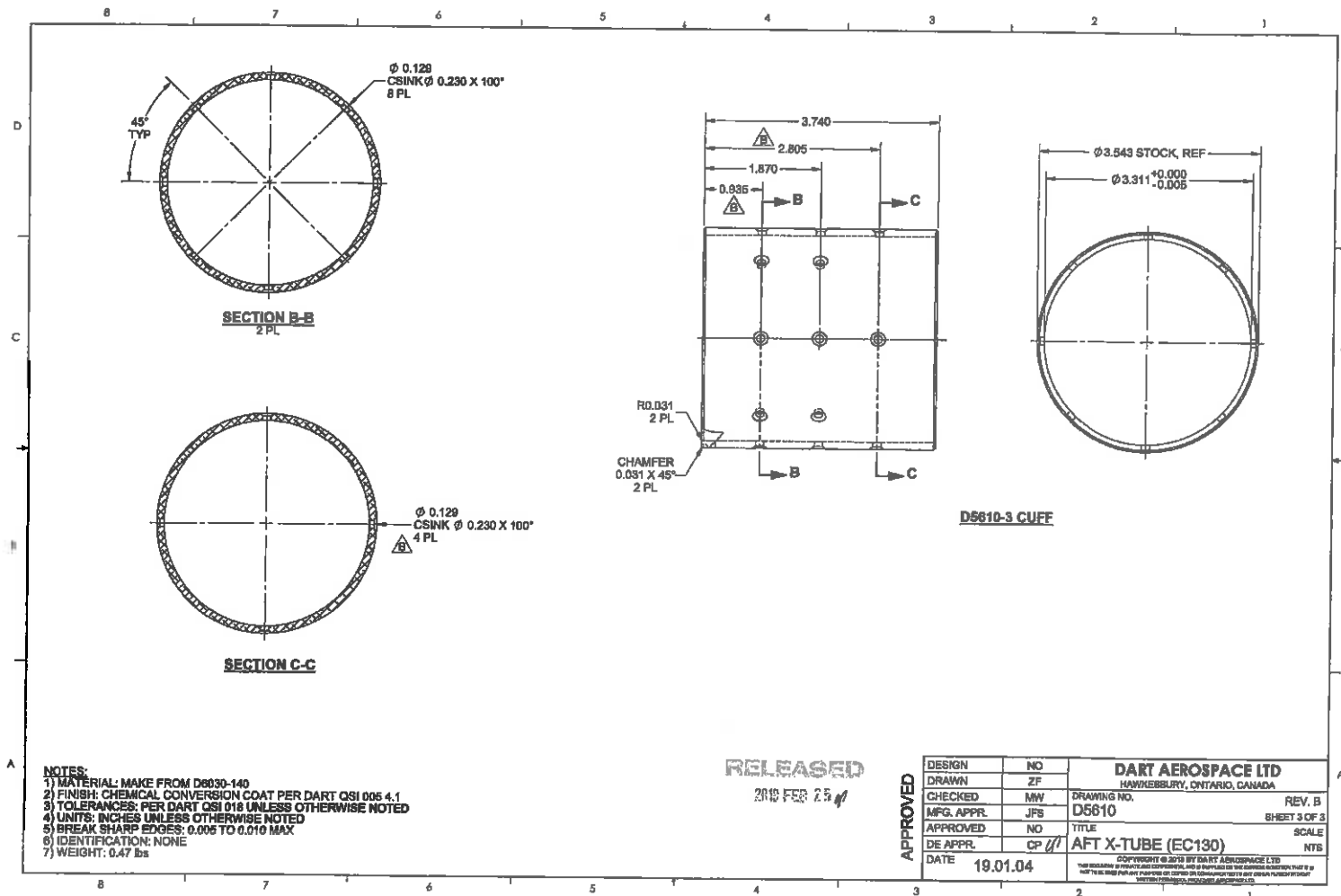
DAS
66
9-89

SCAD

A1953







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DART AEROSPACE LTD		Work Order: 191953
Description: Crosstube Assembly		Part Number: 05610-1TRN
Inspection Dwg: B	Rev: B	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

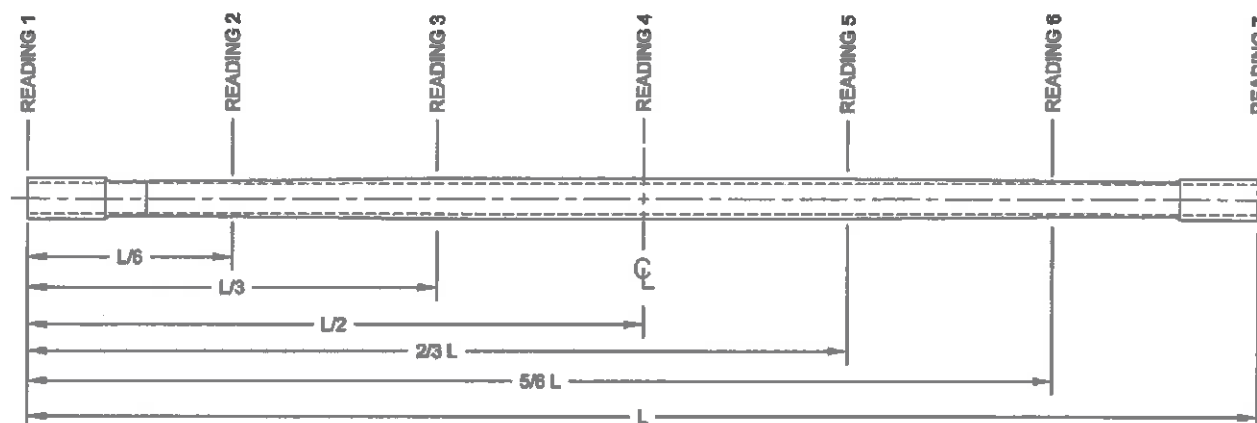
Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	3.300	→ 3.532		✓		CNC-OS ↓	
	3.344			✓			
	3.398			✓			
	3.457			✓			
	3.518			✓			
	3.543			✓			
	3.543			✓			3 Stock, ref
SIDE B	3.300	→ 3.533		✓		CNC-OS ↓	
	3.344			✓			
	3.398			✓			
	3.457			✓			
	3.518			✓			
	3.543			✓			
	3.543			✓			3 Stock, ref
	116.26	±/.030	116.25	✓		tape	

Accepted
4/15/11

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DART AEROSPACE LTD		Work Order: 191953
Description: Crosstube Assembly		Part Number: 05610-1TRN
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WALL THICKNESS MEASUREMENT



Location	WALL THICKNESS MEASUREMENT (IN)				Deviation Δw (max-min)	TOLERANCE
	w1	w2	w3	w4		
READING 1 L= 0"	.200	.204	.195	.190	.014	+/- .030
READING 2 L= 19.38	.257	.266	.248	.239	.027	
READING 3 L= 38.75	.319	.328	.305	.303	.025	
READING 4 L= 58.13	.320	.324	.323	.315	.009	
READING 5 L= 77.51	.294	.323	.323	.308	.029	
READING 6 L= 96.88	.238	.263	.268	.246	.030	
READING 7 L= 116.26	.191	.205	.200	.188	.017	

Calibration Result

Actual Block Thickness: 100-400

Sitescan 250 Measured Thickness: 100-400

Measured by: DAS 66	Audited by: DAS 67	Preliminary Approval:
Date: 2019/03/28	Date: 19-04-01	Date:

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	
C	12.06.01	Wall thickness form added	KJ	

Entered: _____ Date: _____

NCR No. _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only



Job: 191953 Part No. D560-1 TRN		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐											
Date:	Sequence #:	QTY Affected:		MRB (QS1042) N.D. - 19.07.31											
Description Work Order Deviation				Disposition											
Corrosion pitting exceeds allowances				Scrap											
Root Cause				Completed By N.D. - 19.07.31 Lead hand / Supervisor											
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				QC / QA Coordinator 68 9-89 JUL 31 2019											
Other/Details:				FAULT CATEGORY											
				Pressure/Forced Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐				Contamination Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐				Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐			